

Date: Wednesday, 08/10/2008 9:00:22 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
Job Number : 05049
Estimate Number : 10913
P.O. Number :
This Issue : 08/10/2008 S.O. No. :
Prsht Rev. : NC Part Number : D3405043
First Issue : / / Type : R & D LG FAB Drawing Number : D3405 PROTOTYPE
Previous Run : 41764 Project Number : N/A
Written By : Drawing Revision : A
Checked & Approved By : Material :
Comment : Est A 05.09.01 New issue KJ/JLM Due Date : 14/10/2008 Qty: 1 Um: Each

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



PROTOTYPE


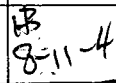
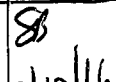
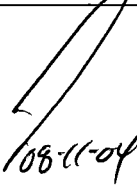
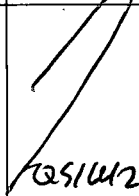
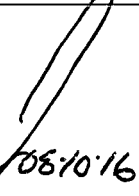
Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 0.125 Sheet
Comment: Qty.: 0.1617 sf(s)/Unit Total: 0.1617 sf(s) 304/316 .125 Sheet (M304S11GA) Batch: 109358 AB 8-10-9		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3405 Dwg Rev: PROTO AB 8-10-9 Prog Rev: TYPE 2-Deburr if necessary AB 8-10-9		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE AB 8-10-9		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 08/10/16 (2) P70		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr Form using DT8204 as per Dwg D3405 SB 08/10/16 (2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See W/O 05048

Part No: D 3405-043 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 08.12.04

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 05049		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.10.16	2.0	Hole Ø0.438" is slightly under size. Ø0.433" → 0.436" R.C: Taper in the cut.		Modify the program to cut the hole to size. drill hole open per dwg & deburr	 8/11/4  08/10/16			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



P70

Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Scrap

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION


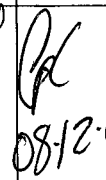
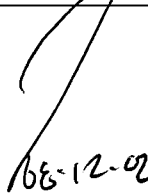
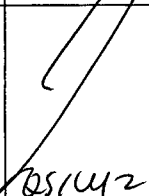



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-02	6-D	2 parts scrap due to design change on the length to achieve a special height and radius		Parts cannot be re-worked to new specs. scrap - destroy.	 08/12/02	 08-12-02	 08/12/02	 08-12-02

NOTE: Date & initial all entries

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Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



**ENGINEERING
APPROVAL**



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

OK
SCRAP RA 08.12.02

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00569

MF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

PROTOTYPE

Product #: D205-634, D204-635 & D206-642

Job #: 00569

Date: 08.10.07

Product Name: GHW LUGS

Requested By: AJS

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3405-041	05046	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	D3405-043 D3405-043	05046	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	D3414-041	05050	LUG ASSY	08.09.23	N	08.10.13	FINISHED CHECK INSTALL PER DSI 9421 REV B	

DART AEROSPACE LTD	Work Order: 05049
Description: Lug Assy	Part Number: D3405-3
Inspection Dwg: D3405-3, Rev: PROTO TYPE	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

x

Prototype

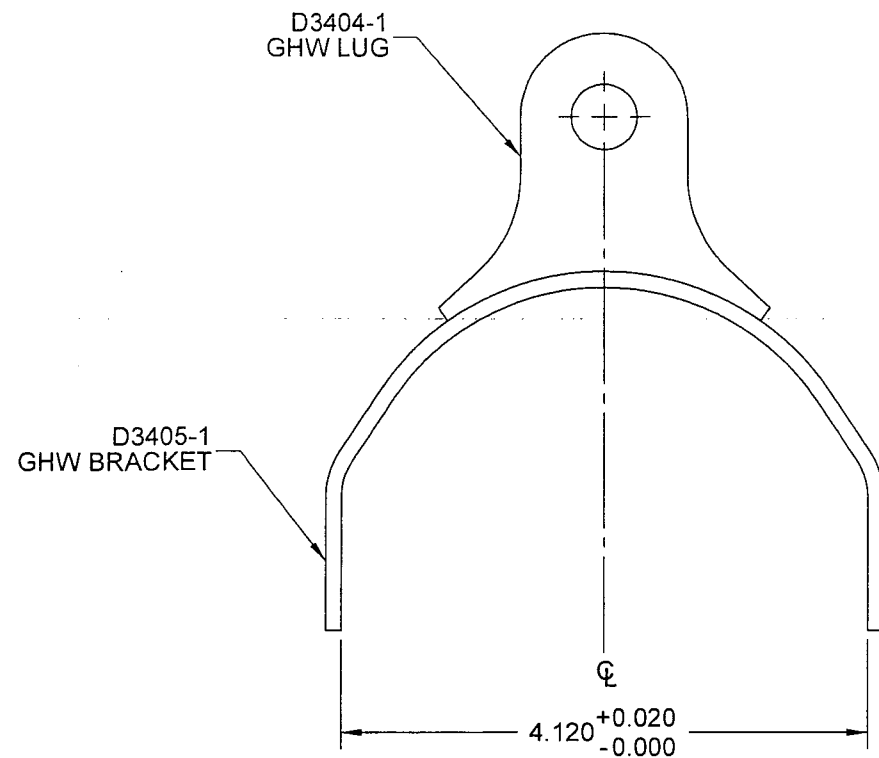
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Measured by:	HB
Date:	8-10-9

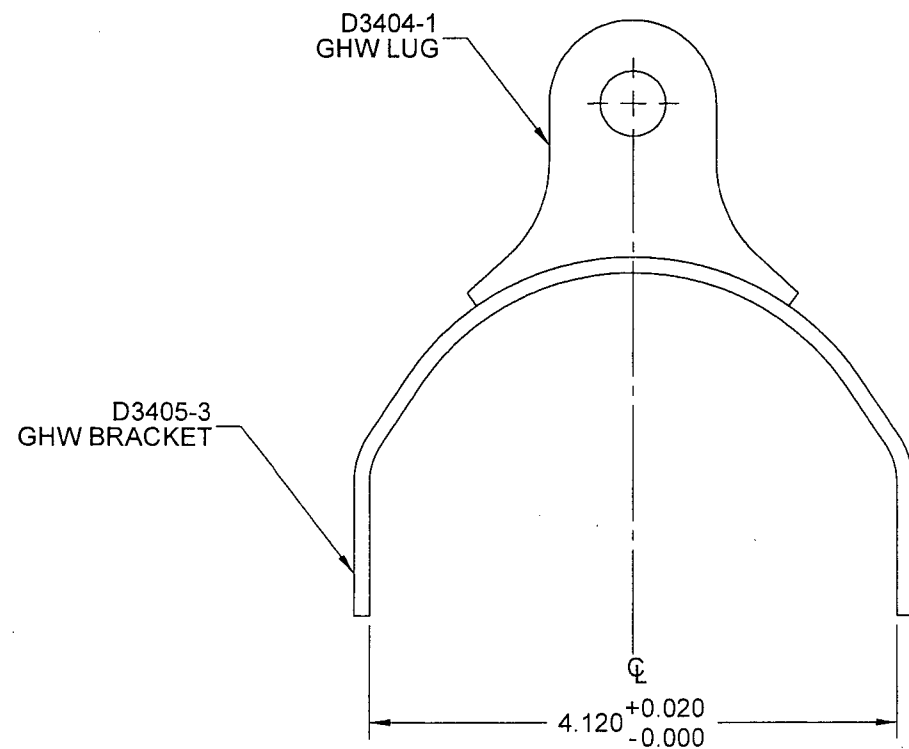
Audited by:	
Date:	25/10/16

Prototype Approval:	
Date:	

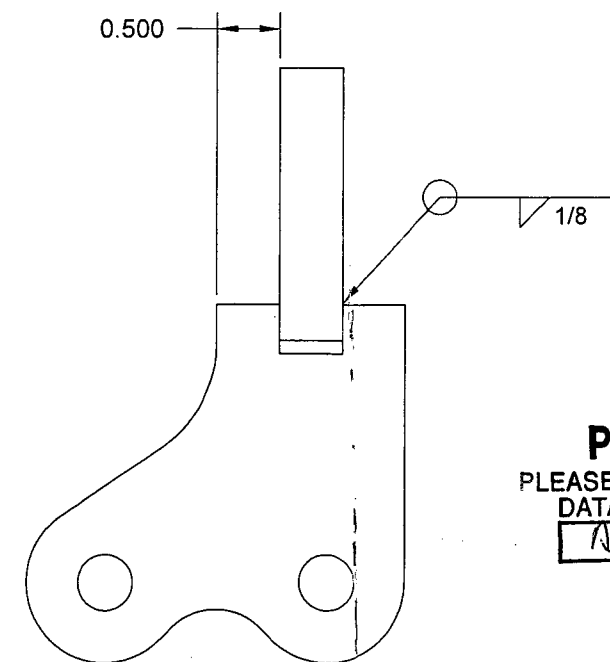
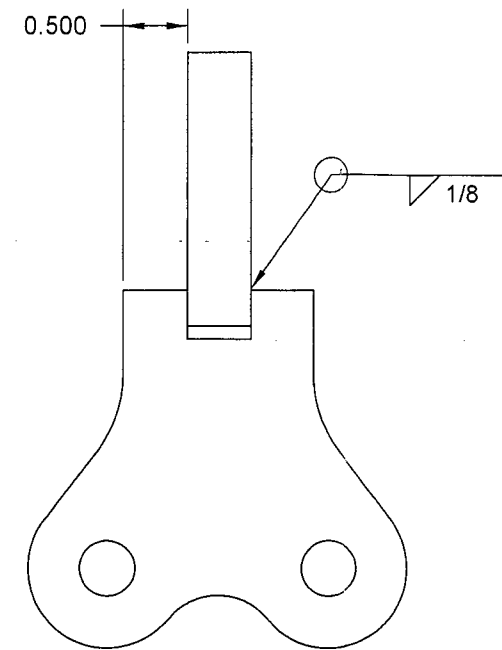
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3405-041 LUG ASSEMBLY



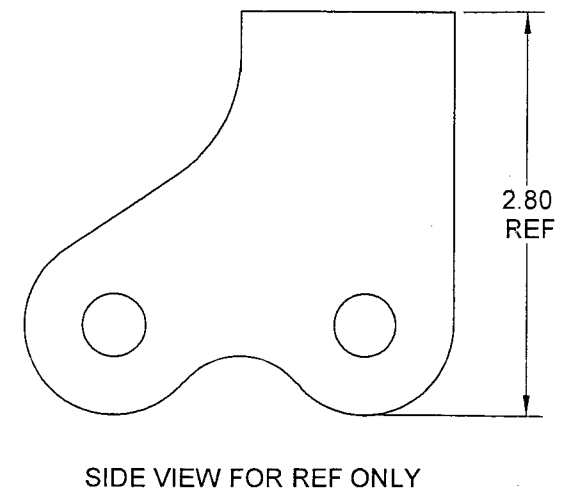
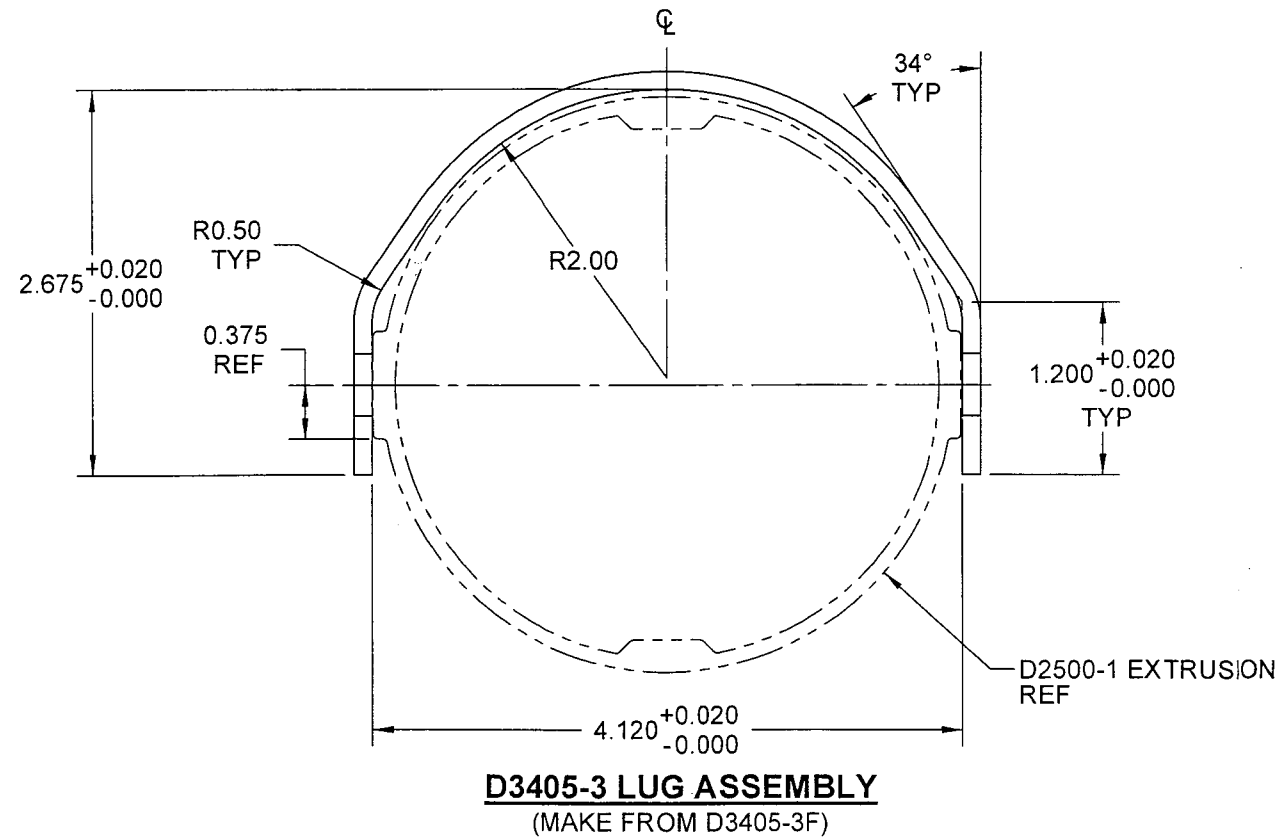
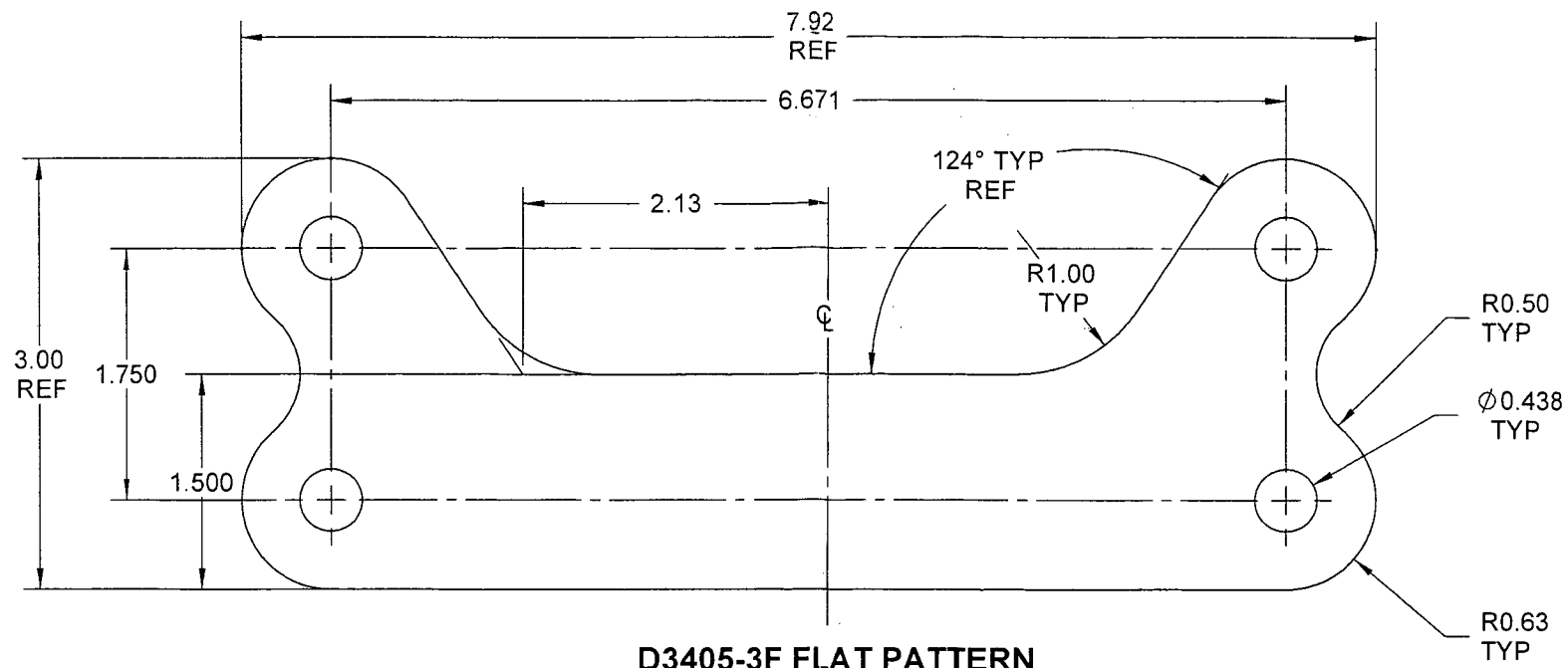
D3405-043 LUG ASSEMBLY



REFERENCE ONLY

PROTOTYPE
PLEASE RETURN ALL ISSUED
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NSS 08.10.17

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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10/5/08.10.07